

## Solid Carbide End Mill Program - High Feed continued



### Quad Force

Tool Ordering No.	Cutter Diameter (D1) Tol. +0/-0.0006	Programmable Radius (R1)	Shank Diameter (D2)	Cutting Length (L1)	Total Length (L2)
QFM-0125-HSN	1/8"	0.018"	0.125	0.500	1.500
QFM-0187-HSN	3/16"	0.021"	0.187	0.625	2.000
QFM-0250-HSN	1/4"	0.032"	0.250	0.750	2.500
QFM-0375-HSN	3/8"	0.140"	0.375	1.000	2.500
QFM-0500-HSN	1/2"	0.170"	0.500	1.200	3.000
QFM-0625-HSN	5/8"	0.200"	0.625	1.450	3.500
QFM-0750-HSN	3/4"	0.250"	0.750	1.700	4.000
QFM-1000-HSN	1"	0.310"	1.000	2.200	4.000



### Quad Force Application Data

Side/Slot Milling		High Feed Machining		Trochoidal		Plunge Milling	
Tool	QFM-0375-HSN	Tool	QFM-0375-HSN	Tool	QFM-0375-HSN	Tool	QFM-0375-HSN
Tool Diameter	0.375"	Tool Diameter	0.375"	Tool Diameter	0.375"	Tool Diameter	0.375"
Spindle Speed	6265 RPM	Spindle Speed	6265 RPM	Spindle Speed	6265 RPM	Spindle Speed	6265 RPM
Feed Rate	225 IPM	Feed Rate	225 IPM	Feed Rate	225 IPM	Feed Rate	225 IPM
Depth of Cut	0.750"	Depth of Cut	0.012"	Depth of Cut	0.750"	Depth of Cut	0 - 0.750"
Width of Cut	0.012"	Width of Cut	0.225"	Width of Cut	0.012"	Width of Cut	0.012"
Metal Removal Rate	2.03	Metal Removal Rate	1.12	Metal Removal Rate	2.03	Metal Removal Rate	2.03
Material	P20	Material	P20	Material	P20	Material	P20



## Solid Carbide End Mill Program - High Feed continued



### Quad Force

Tool Ordering No.	Cutter Diameter (D1) Tol. +0/-0.0006	Programmable Radius (R1)	Shank Diameter (D2)	Cutting Length (L1)	Total Length (L2)
QFM-04-HSN	4mm	0,57	4mm	14mm	51mm
QFM-06-HSN	6mm	0,80	6mm	20mm	63mm
QFM-08-HSN	8mm	1,10	8mm	20mm	63mm
QFM-10-HSN	10mm	3,30	10mm	25mm	70mm
QFM-12-HSN	12mm	4,20	12mm	29mm	76mm
QFM-16-HSN	16mm	5	16mm	37mm	89mm

**Quad Force**  
MACHINING

### Quad Force Application Data

Side/Slot Milling		High Feed Machining		Trochoidal		Plunge Milling	
Tool	QFM-10-HSN	Tool	QFM-10-HSN	Tool	QFM-10-HSN	Tool	QFM-10-HSN
Tool Diameter	10mm	Tool Diameter	10mm	Tool Diameter	10mm	Tool Diameter	10mm
Spindle Speed	6265 RPM	Spindle Speed	6265 RPM	Spindle Speed	6265 RPM	Spindle Speed	6265 RPM
Feed Rate	5700	Feed Rate	5700	Feed Rate	5700	Feed Rate	5700
Depth of Cut	20mm	Depth of Cut	0.3mm	Depth of Cut	20mm	Depth of Cut	0 - 20mm
Width of Cut	0.3mm	Width of Cut	6mm	Width of Cut	0.3mm	Width of Cut	0.3mm
Metal Removal Rate	34.2	Metal Removal Rate	10.26	Metal Removal Rate	34.2	Metal Removal Rate	34.2
Material	P20	Material	P20	Material	P20	Material	P20

